

Work Order ID 78562

ASAP
78562

Page 1

January-11-12 9:49:56 AM

Item ID: D4410-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Conduit

Start Date: 1/11/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4410	A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

BEND AS PER DWG

DEBURR

SP 12/01/11

(1)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8 12/01/11

(H)

120

Identify as per dwg & Stock Location: *W/O*

0.00

120

Packaging

Memo

0.00

Packaging

W/O 78510

EZ 12-1-11

(E)

Work Order ID 78562***78562***

Page 2

January-11-12 9:49:56 AM

Item ID: D4410-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Conduit

Start Date: 1/11/12 Start Qty: 1.00 ***1***

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Required Date: 1/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/11/12
MK
12-01-10

Picklist Print

January-11-12 9:49:56 AM

Page 1

Work Order ID: 78562

Parent Item: D4410-7

Parent Item Name: Conduit

Start Date: 1/11/12

Required Date: 1/13/12

Start Qty: 1.00

Required Qty: 1.00

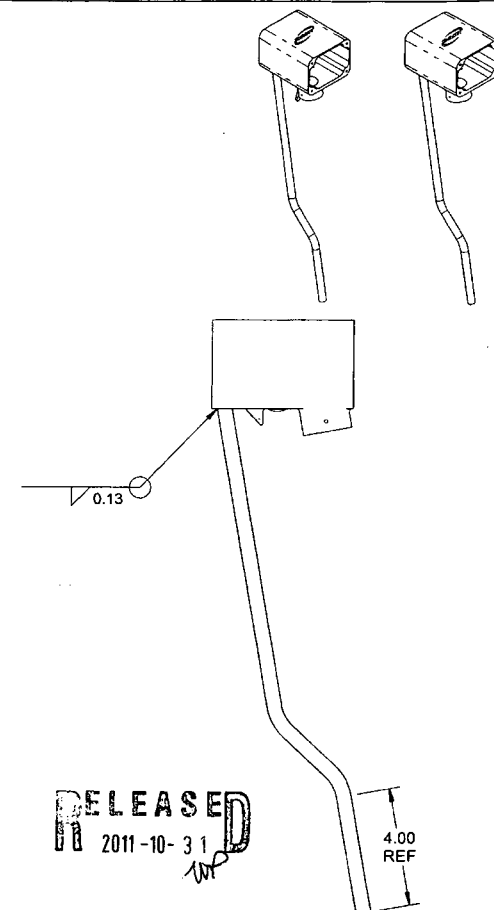
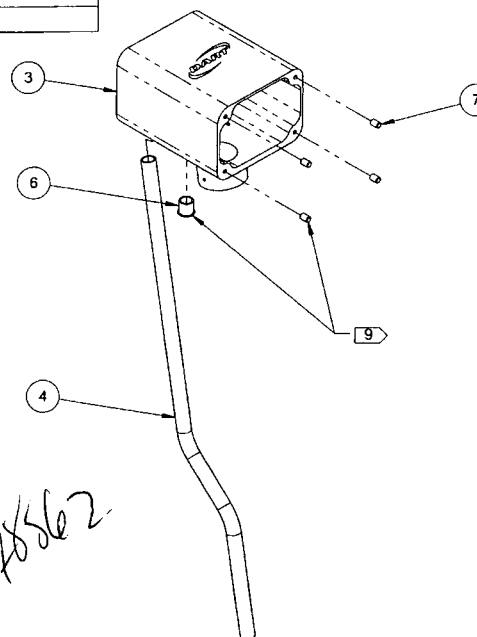
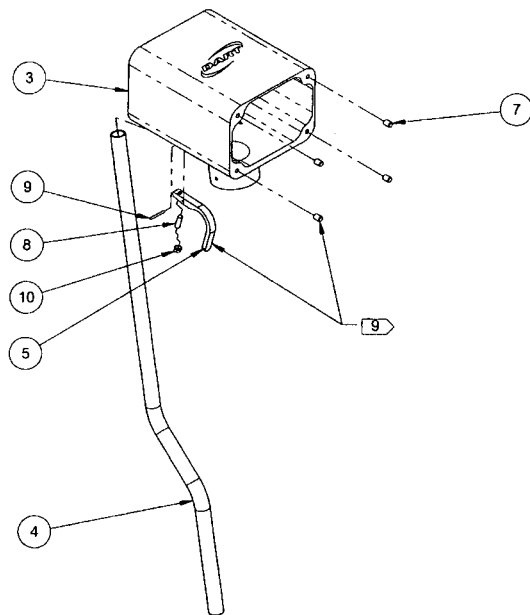
Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049 6061-T6 RD Tube .500 x.049W		Purchased	No				f	218.1735		1.7894737			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT014		218.173481							
				117270		218.173481							

SP 12/01/12

2

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2		X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
3	1	1	D4410-1	CO-PILOT COLLECTIVE HEAD
4	1	1	D4410-7	CONDUIT
5	1		D4410-9	TRIGGER
6		1	D4413-1	DOME PLUG
7	4	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1		AN565F8H7	SETSCREW
9	1		MS20253-1-65	PIN
10	1		MS21042L08	NUT



W/ 78562

RELEASED
2011-10-31

D4410-043 WELDING DETAIL
(-043 SHOWN, -041 SIMILAR)

D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

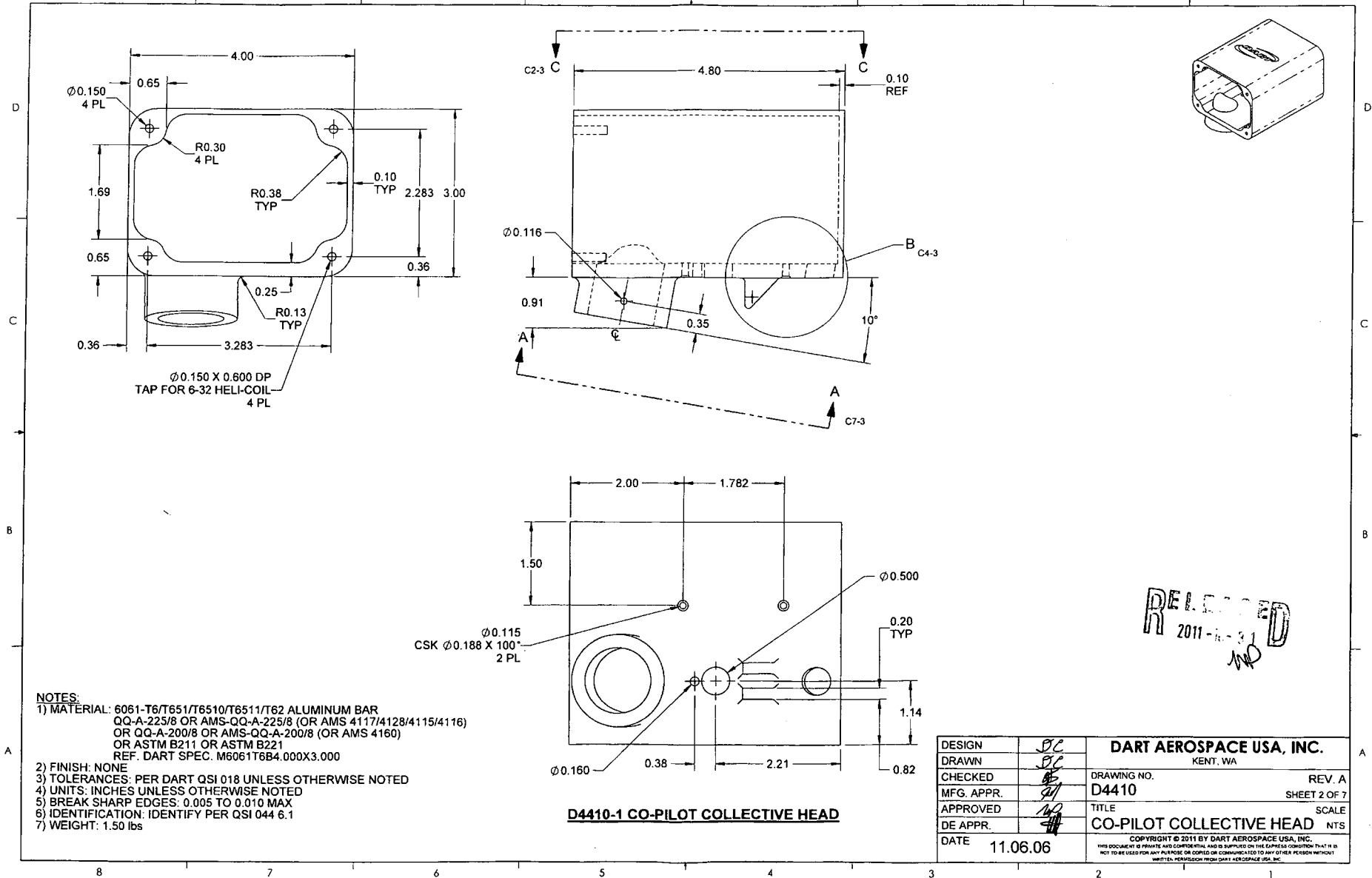
D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

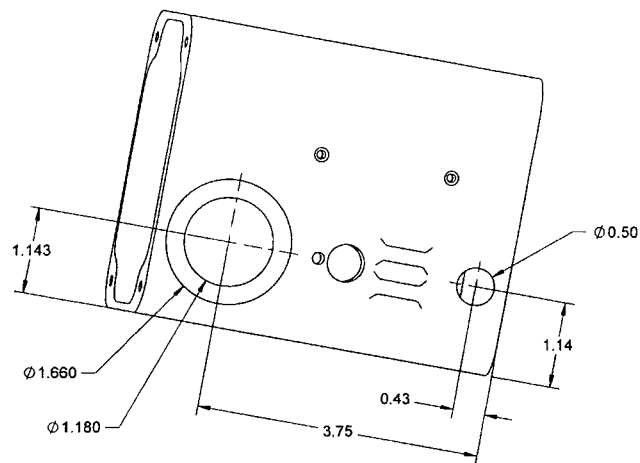
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.64 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSTALL AFTER ANODIZING

REV.	DESCRIPTION	DC	DATE
A	NEW ISSUE	BY	11.06.06
DESIGN	BC	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4410 REV. A SHEET 1 OF 7 TITLE CO-PILOT COLLECTIVE HEAD SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	11.06.06		

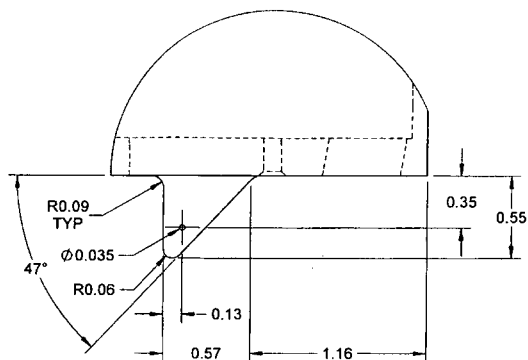
8 7 6 5 4 3 2 1





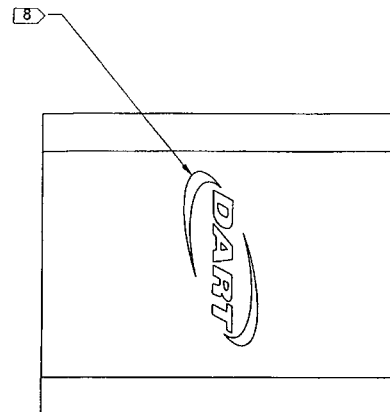
**VIEW A-A
SCALE 1X**

C5-2



**DETAIL B
SCALE 2X**

C4-2



**VIEW C-C
SCALE 1X**

D4-2

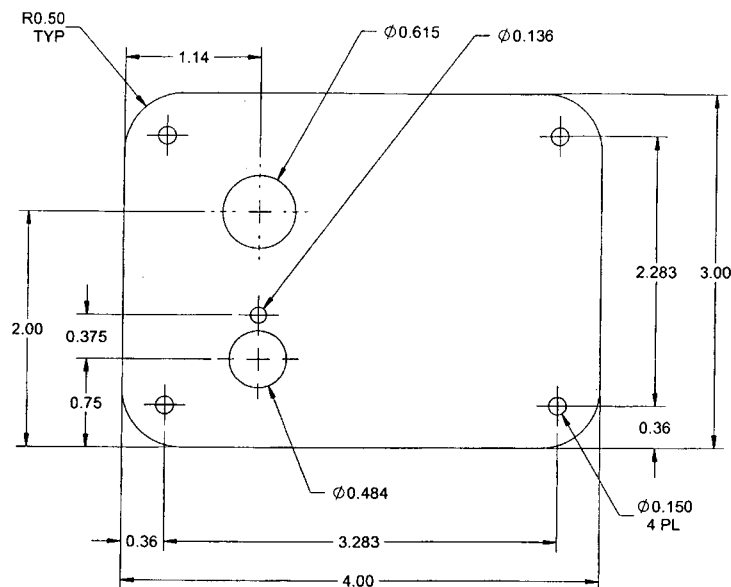
**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

RELEASED
2011-10-31

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

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MFG. APPR.	AE	D4410	SHEET 3 OF 7
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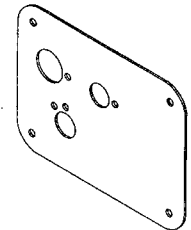
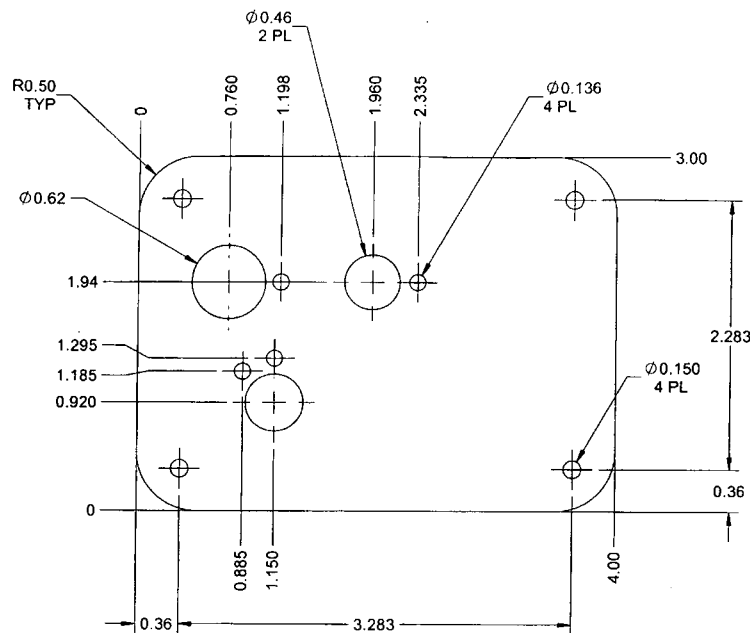
D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

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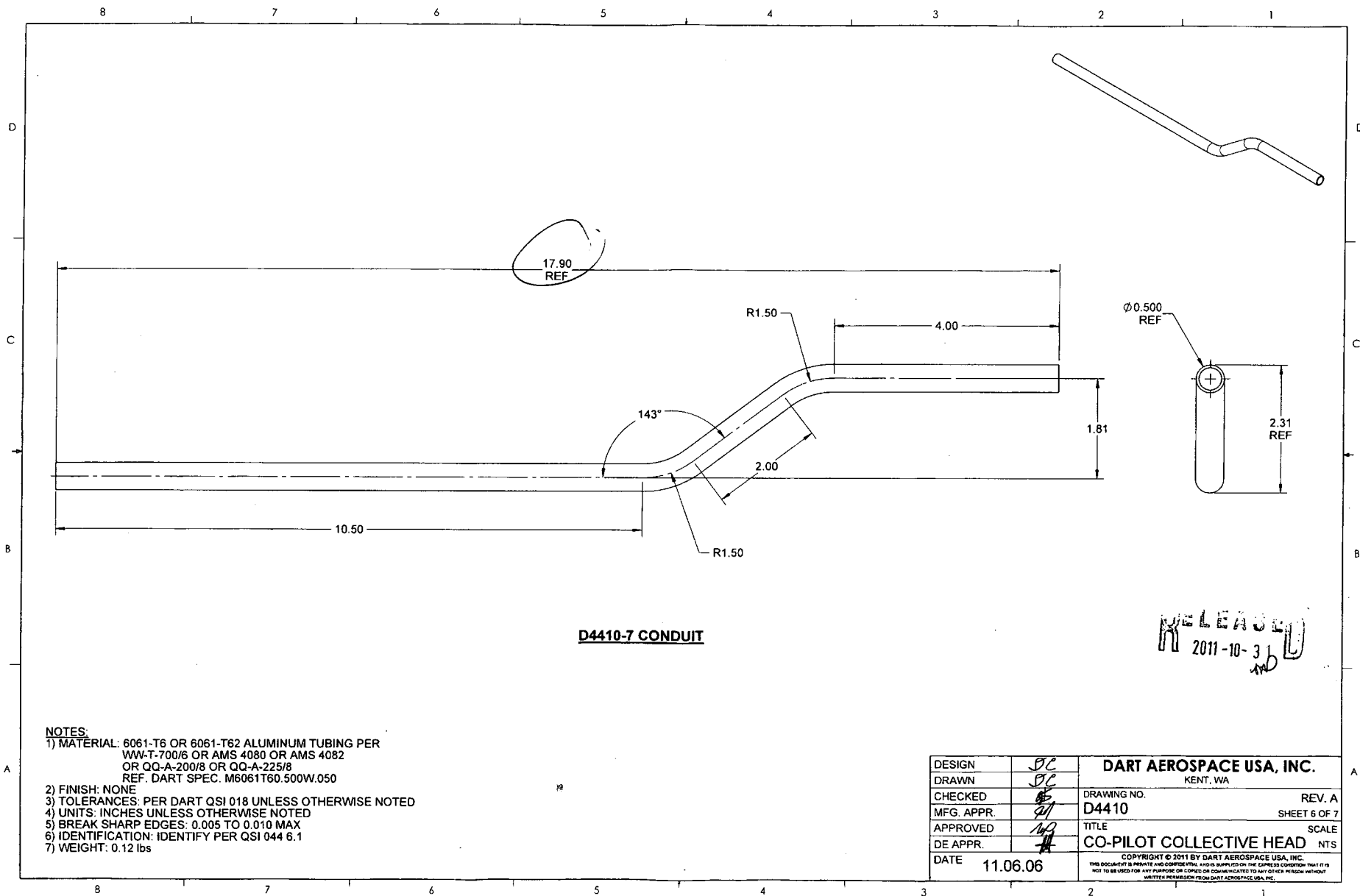
D4410-5 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

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2011-10-30
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D4410-7 CONDUIT

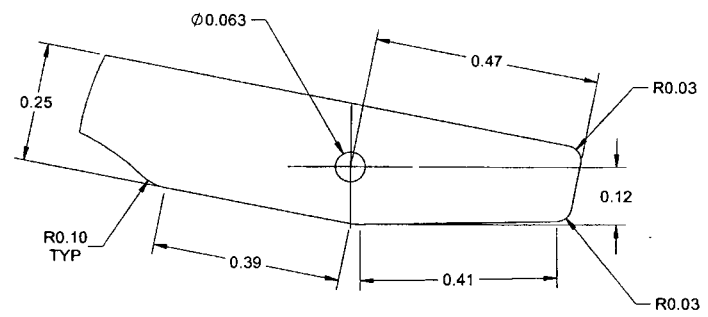
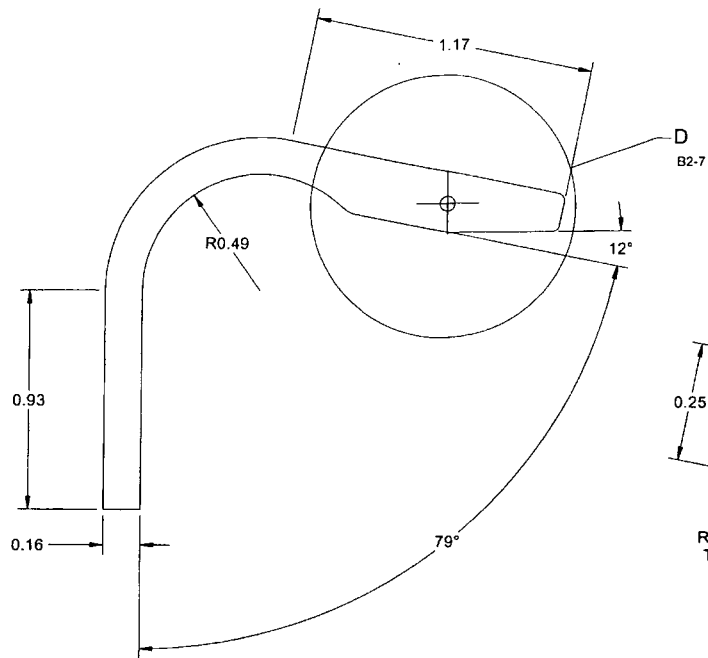
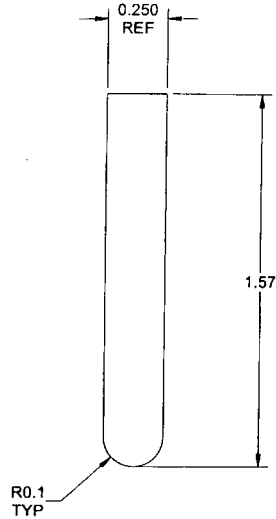
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2011-10-31

NOTES:

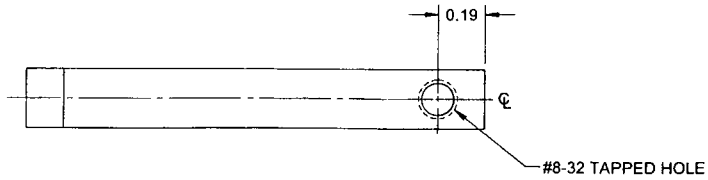
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER
WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T60.500W.050
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

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MFG. APPR.	SP	D4410	SHEET 6 OF 7
APPROVED	MD	TITLE	SCALE
DE APPR.	A	CO-PILOT COLLECTIVE HEAD	NTS
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8 7 6 5 4 3 2 1



DETAIL D
SCALE 2X
D4-7



D4410-9 TRIGGER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

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MFG. APPR.	21	D4410	SHEET 7 OF 7
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DE APPR.	11	CO-PILOT COLLECTIVE HEAD	NTS
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8 7 6 5 4 3 2 1